

Work Order ID 79969

79969

Page 1

Wednesday, February 08, 2012 10:08:58 AM

Item ID: D4575-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 2/8/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *12-02-09* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4575	A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

2024 .063

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr as required

B12-2-21

~~*100-1-1*~~

(7)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W 12 1 02 22 (7)

130

Chemical Conversion Coat per QS1005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

7 @P/M/Feb 22/2012

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

7 12 12 22

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: 197

0.00

150

Packaging

Memo

0.00

Packaging

12/2/23 12/2/23

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/2/23 12/2/23

12-02-23 7

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, February 08, 2012 10:08:58 A

Page 1

Work Order ID: 79969

Parent Item: D4575-3

Parent Item Name: Doubler

Start Date: 2/8/2012

Required Date: 2/17/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.01.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

2024-T3 .063 sheet

Purchased

No

100

sf

211.5000

0.2557

1.0766316

1.5
B12-2-21

Location

Loc Qty

Loc Code

MAT022

211.5

117392

19.5

119916

192

117392

Ⓟ

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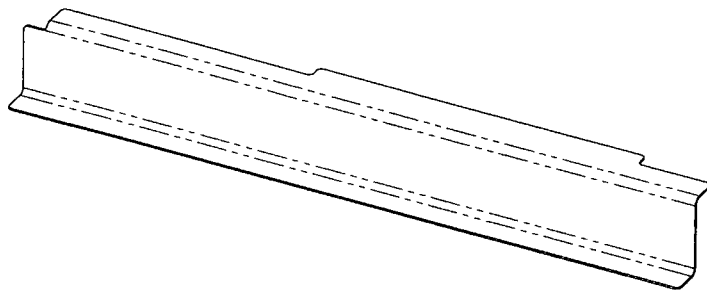
8 7 6 5 4 3 2 1

D

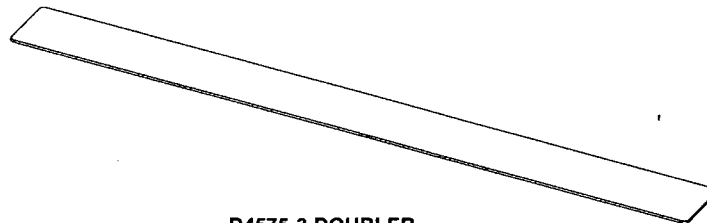
C

B

A



D4575-1 BEAM



D4575-3 DOUBLER

79969

RELEASED
2012-01-13
MD

A	NEW ISSUE	MB	12.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4575 TITLE REINFORCEMENT SCALE NTS	REV. A	SHEET 1 OF 3
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.01.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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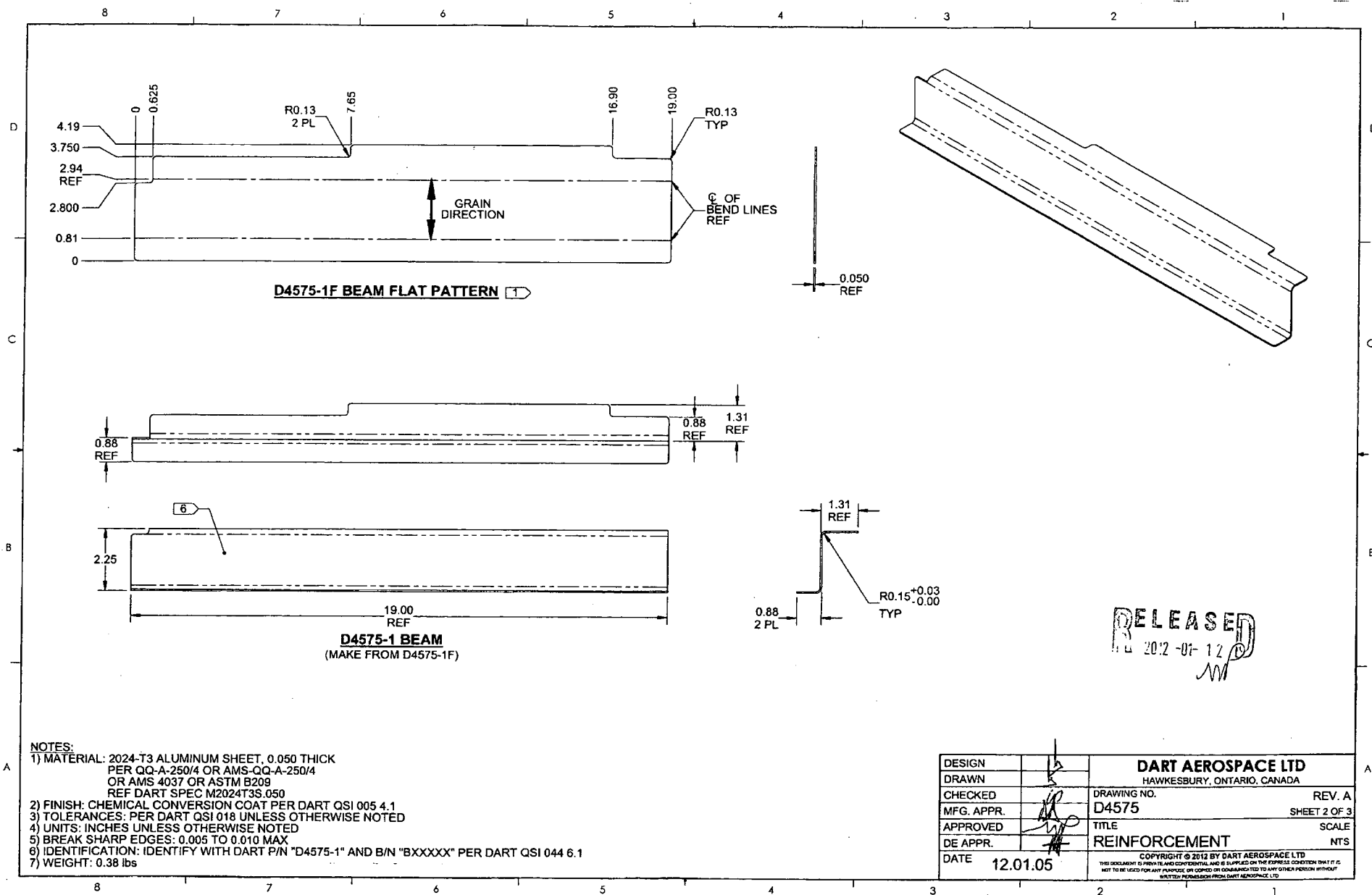
W/O:		WORK ORDER CHANGES					
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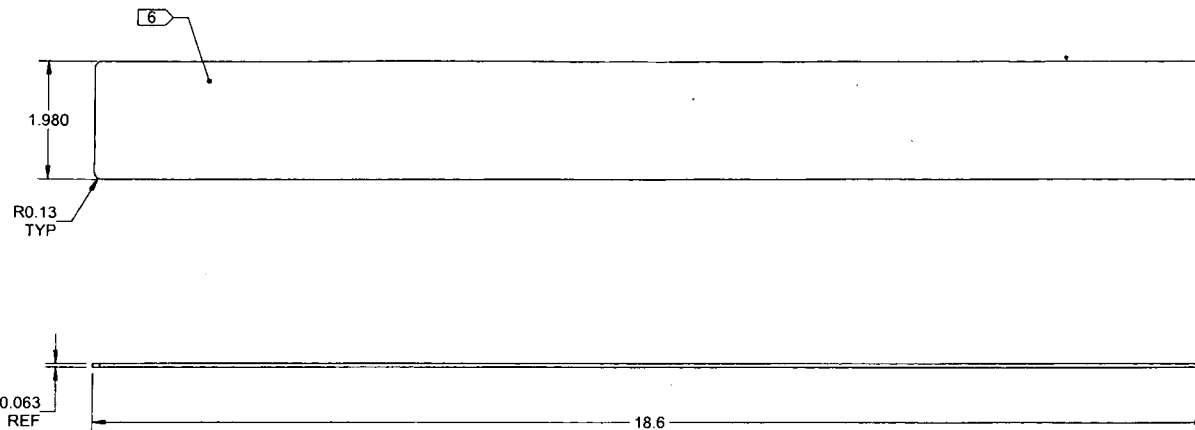
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D4575-3 DOUBLER

RELEASED
2012-01-12

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4575-3" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4575	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REINFORCEMENT	NTS
DATE	12.01.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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Work Order: 79869

Part Number: D45753

Page 1 of 1

X	First Article	X	Prototype
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Measured by: B	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 12-2-24	Date: 12.02.22	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revD